

DART

DESIGN DS	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3218	REV. C SHEET 1 OF 2
DATE 04.12.01	TITLE FLOAT ASSEMBLY		SCALE NTS
A	03.10.06	NEW ISSUE	
B	04.10.26	ADD BONDING/TESTING/MFG SPEC	
C	04.12.01	UPDATE NOTE #1, #2, & #4	

RELEASED
04.12.16 *H***D3218-041 FLOAT ASSEMBLY, NOTES:**

1) MATERIAL:

ITEM	DESCRIPTION	QTY
FABRIC	POLYURETHANE COATED, PENNEL 987-123 YELLOW	7.20 m
ADHESIVE	SEALREZ S-0345 A/B	2.50 L
WEBBING	LAGRAN #3003, 1" WHITE NYLON	0.31 m
THREAD	NYLON, TWISTED TYPE II, SIZE F, CLASS A, V-T-295, COLOR TAN	5.00 yds
NYLON CORD	MIL-C-5040 TYPE III, COLOR NATURAL	1.60 m
LETTERING	COATES SCREEN C99 S170 BLACK, HIGH GLOSS	0.50 oz
INFLATION VALVE	MIRADA B-51016 / A-51265	2
PRESSURE RELIEF VALVE	MIRADA B-51019	2
TOPPING VALVE	MIRADA B-51209	2
FLANGE	MIRADA B-51014-N (4.25")	4
FLANGE	HALKEY ROBERTS 981001020 (3.5")	2

- 2) ADHESIVE BONDING TO BE PERFORMED I.A.W. TULMAR PCS 002 REV. D USING AN ADHESIVE THICKNESS OF 0.008' +/- 0.003" (3 COATS). COUPON TESTING TO BE PERFORMED I.A.W. TULMAR PCS 006 REV. C. MANUFACTURING PROCESS IS DEFINED BY TULMAR PIF #193-8927 REV. E

3) AFTER MANUFACTURE:

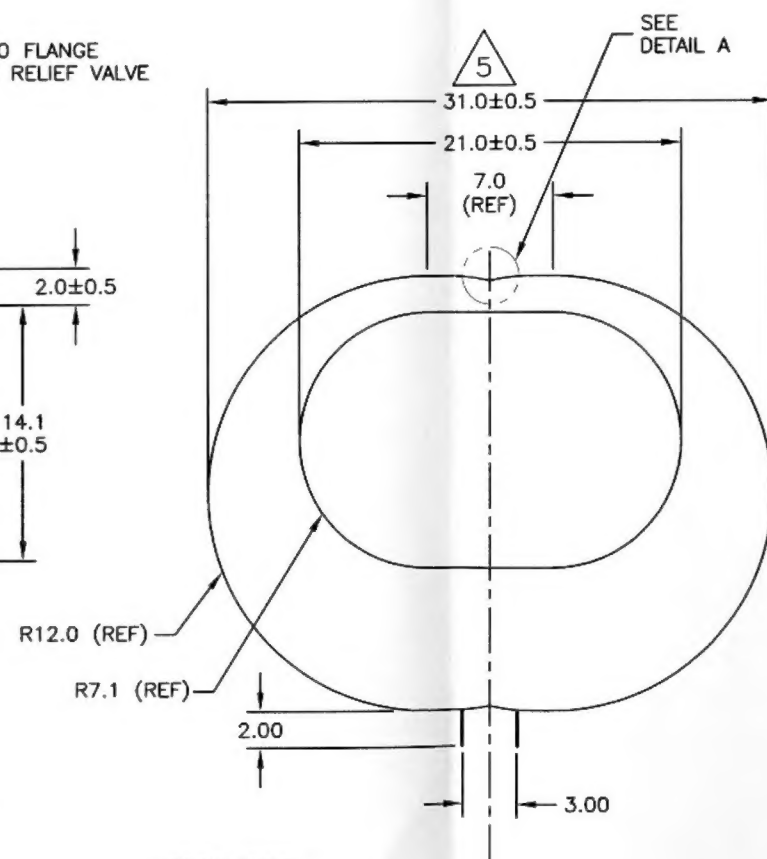
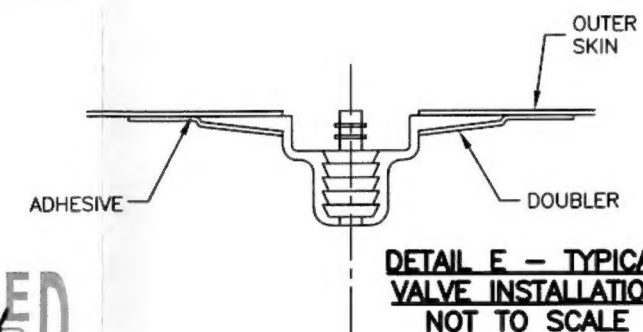
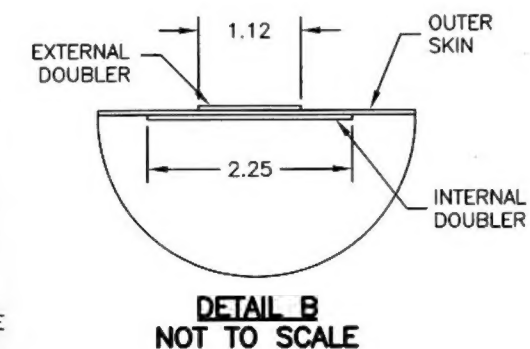
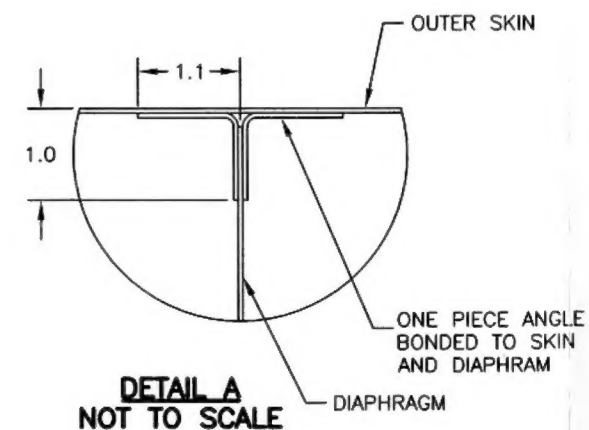
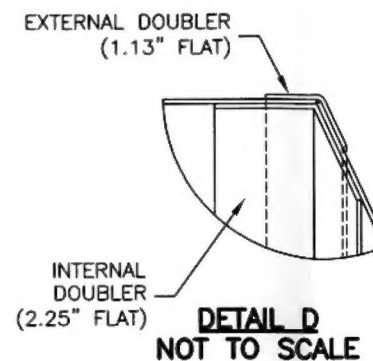
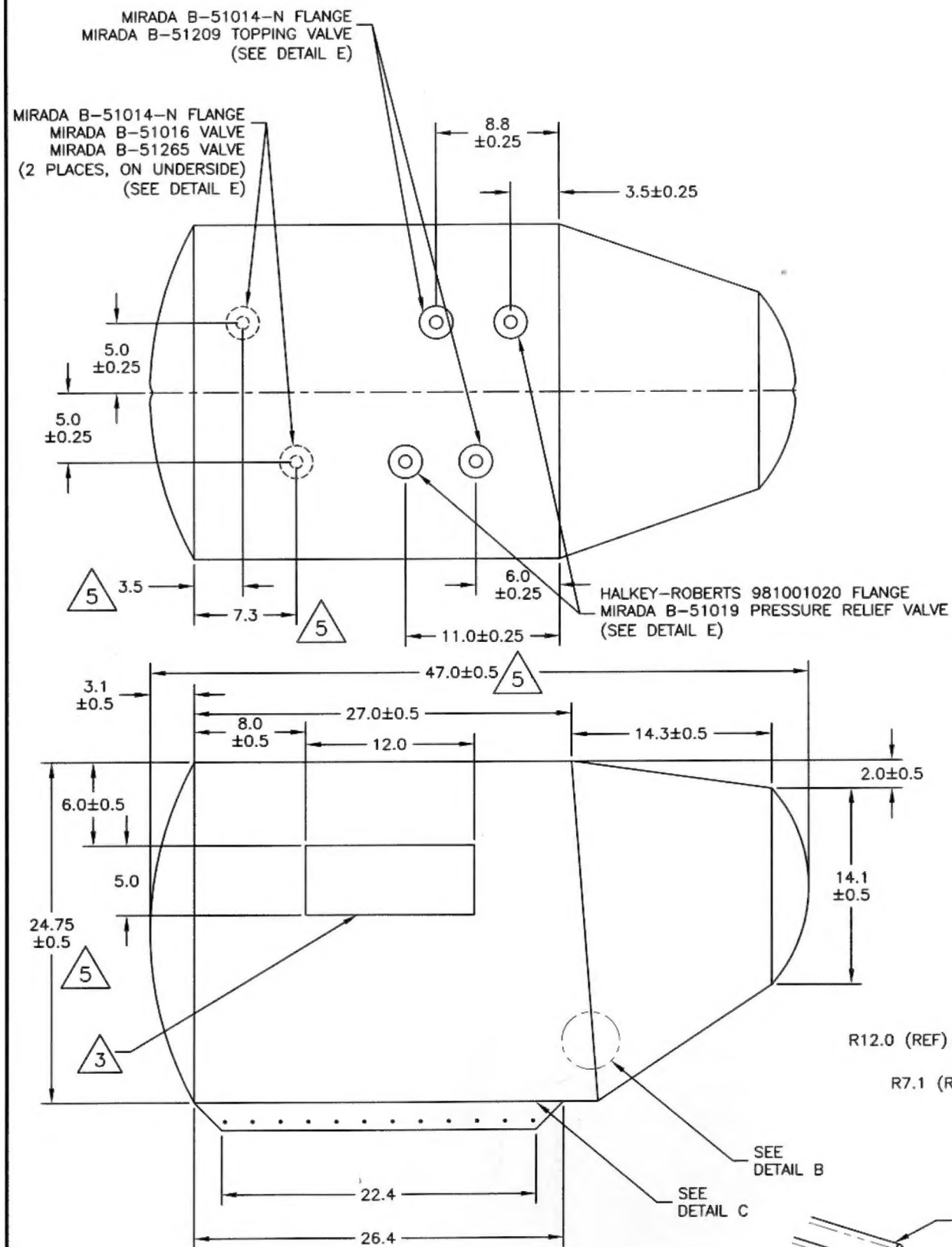
- (a) PRESSURE TEST EACH CHAMBER TO 4.36 PSI (30 kPa) FOR 5 MINS.
 - (b) INFLATE TO RELIEF VALVE PRESSURE [MIN OF 3.00 PSI (20.6 kPa)]. RELIEF VALVE MUST OPEN AT 3.3-3.5 PSI AND MUST CLOSE AT NOT LESS THAN 3.00 PSI. BAG MUST MAINTAIN A MIN PRESSURE OF 1.6 PSI (11.0 kPa) FOR 24 HOURS.
- 4) FLOAT IDENTIFICATION LETTERING 0.313" (7.95mm) HIGH BLACK CAPITAL LETTERS STENCILED ON THE R/H SIDE OF THE FLOAT BAG AS FOLLOWS:

DART AEROSPACE LTD.
FLOAT ASSEMBLY
P/N D3218-041 S/N BXXXXX-XX
REPLACES HELITECH P/N 358-008-001
WWW.DARTAERO.COM

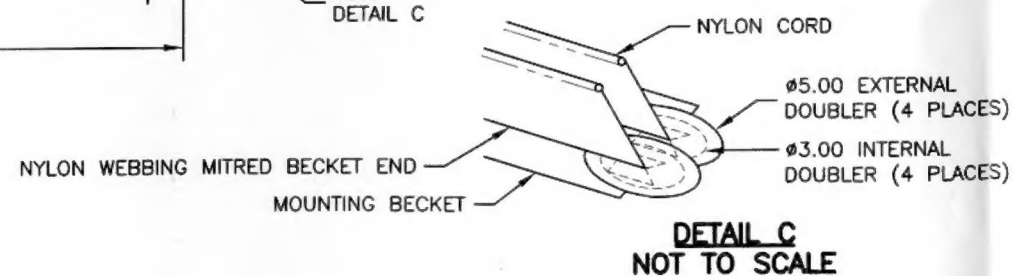
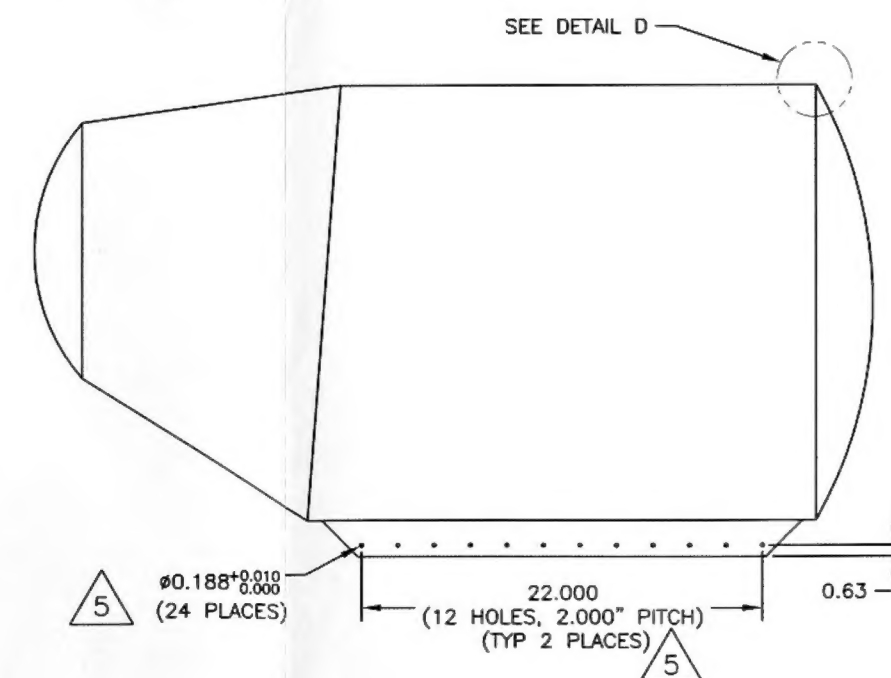
- 5) COATED SIDE OF FABRIC ON OUTSIDE OF BAG.
- 6) ALL DIMENSIONS ARE IN INCHES. CRITICAL DIMENSIONS (DENOTED BY \triangle) MUST BE OBTAINED AT 2 PSI.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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RELEASED
04.12.16



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DESIGN DS	DRAWN BY P	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3218	REV. C SHEET 2 OF 2
DATE 04.12.01	TITLE FLOAT ASSEMBLY	SCALE 1:10	